

Date: Thursday, 02/04/2009 2:29:42 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	INNER FWD SADDLE	
Job Number :	46902			
Estimate Number :	11079			
P.O. Number :		Part Number :	D5953	
This Issue :	02/04/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D5953 REVB	
First Issue :	/ /	Project Number :	N/A	
Previous Run :	43247	Drawing Revision :	B	
Written By :		Material :		
Checked & Approved By :	JLD 09.04.03	Due Date :	24/04/2009	Qty: 4 Um: Each
Comment :	Est Rev:E Re-Format 05-11-29 JLM Est Rev:f ecn 826 06.12.06 EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D6101007	Saddle Billet
-----	----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 D6101-007(7075-T7351)
 Size 2.50" x 7.50" X 8.25" (Grain along 7.50")
 Batch: H6412

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
-----	-------	--------------------------------

**Comment:** HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5953, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

JL 09/04/05

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------

**Comment:** INSPECT ALL DIM TO DIM SHEET

JL 09/04/05

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

JF 09/04/06

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

UMD/PR

09/04/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:29:42 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER FWD SADDLE

Job Number: 46902

Part Number: D5953

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:00

OVEN TEMPERATURE:

320°

FINISH TIME:

1:30

09-04-06

(4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/06

(4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 425

9/4/7

SP

(4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/08

Job Completion



mf
09-04-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46902
Description: Inner Fwd Saddle		Part Number: D5953
Inspection Dwg: D5953		Rev: B
		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.248	5.249	5.249	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.318	.318	.318	.318		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.579	4.579	4.579		
K	0.315	0.322		.318	.318	.318	.318		
L	0.495	0.505		.499	.498	.499	.499		
M	0.490	0.510		.499	.498	.498	.499		
N	1.615	1.635		1.625	1.620	1.627	1.627		
O	7.990	8.010		8.000	8.000	8.001	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.312	.310	.309	.309		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.495	.500	.498	.499		
T	1.375	1.395		1.388	1.390	1.389	1.387		
U	2.000	2.020		2.012	2.013	2.012	2.011		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

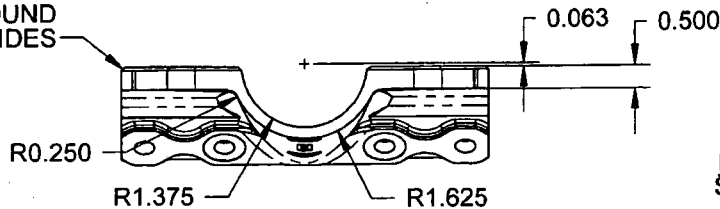
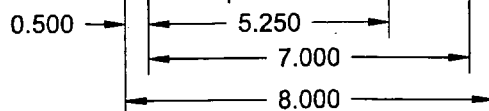
Measured by:	J.L.
Date:	09/04/05

Audited by:	JB
Date:	09/04/06

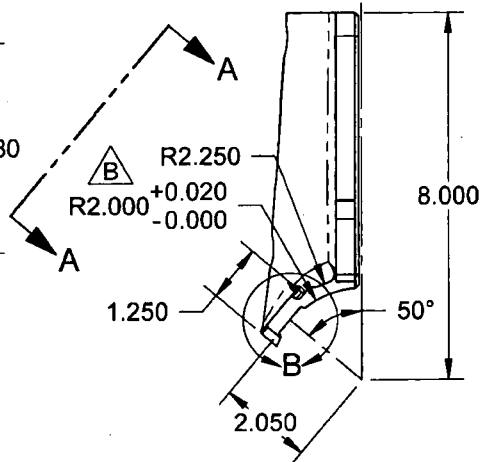
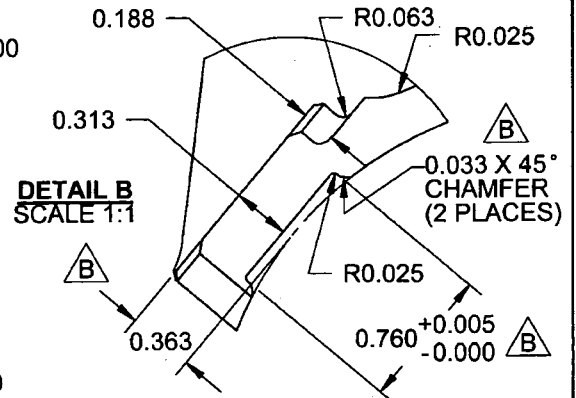
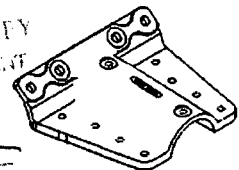
Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	
F	08.12.01	Dimension K revised	KJ/DD	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5953
DATE 06.11.07	TITLE INNER FWD SADDLE	REV. B SHEET 1 OF 1
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM

RELEASED
06.11.28CHAMFER
0.075 X 45°
ALL AROUND
BOTH SIDESENGRAVE PART NO.
AND BATCH NO.
WITH MIN RAD OF
0.010 TO MAX
DEPTH OF 0.010R0.500
 $\phi 0.316$
(8 PLACES)DRILL $\phi 0.316$ THRU
 $\phi 0.750$ SPOT FACE
(2 PLACES) $\phi 0.920$ SPOT FACE
(2 PLACES)GRAIN
DIRECTIONR0.660
 $\phi 0.438$
(4 PLACES)

VIEW A-A

0.040 X 45° CHAMFER
ALL AROUND**D5953 INNER FWD SADDLE**SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44000**ISOMETRIC VIEW**
SCALE 1:8**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

COPYRIGHT © 1997 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.